

Date: Monday, 8/27/2007 1:03:37 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DRAIN TUBE ASSEMBLY
Job Number : 34268	
Estimate Number : 13002	
P.O. Number : <i>N/A</i>	Part Number : D2127251917
This Issue : 8/27/2007 S.O. No. : <i>N/A</i>	Drawing Number : D212-725-1 PG34 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/3/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature] 07.08.27</i>	
Comment : Est Rev:A New Issue 07-07-27 JLM	Verified By:

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0375W035	304 TUBING
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Comment: Qty.: 2.0000 f(s)/Unit Total : 12.0000 f(s)

304 TUBING .375" o.d X .035" Wall

Batch: *[Redacted] M18993*

*FF 07-08-28 6*

2.0	SMALL FAB RESOURCE 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form tube as per Dwg D212-725-1 & DT8910 Template

2-Install sleeves & nut then flare tube as per Dwg D212-725-1.

*FF 07/08/30*

*(PTO)*

3.0	AN8186J	nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

nut

Batch: *M102850*

*FF 07-08-29 6*

4.0	MS208196J	sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

sleeve

Batch: *m 102850*

*FF 07-08-29 6*

5.0	QC5	INSPECT WORK TO CURRENT STEP
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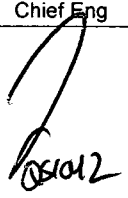
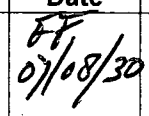
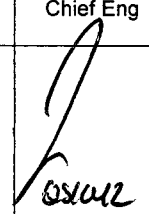


Comment: INSPECT WORK TO CURRENT STEP

*En 07/08/31 (46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/08/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/30	2	Dwg didn't match Template & add 16. figure out flat piece 4 piece were scrap 2.5 wrong dwg was supplied.	 08/08/31	Scrap & destroy replace	 07/08/30	Er 07/08/31	 08/08/31	Er 07/08/31

NOTE: Date & initial all entries

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Drawing Name: DRAIN TUBE ASSEMBLY

Job Number: 34268

Part Number: D2127251917

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PO 7/18/31*

*(6)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(6)*

Comment: FINAL INSPECTION/W/O RELEASE

*2 07/08/31*

Job Completion



*U 07-08-31*

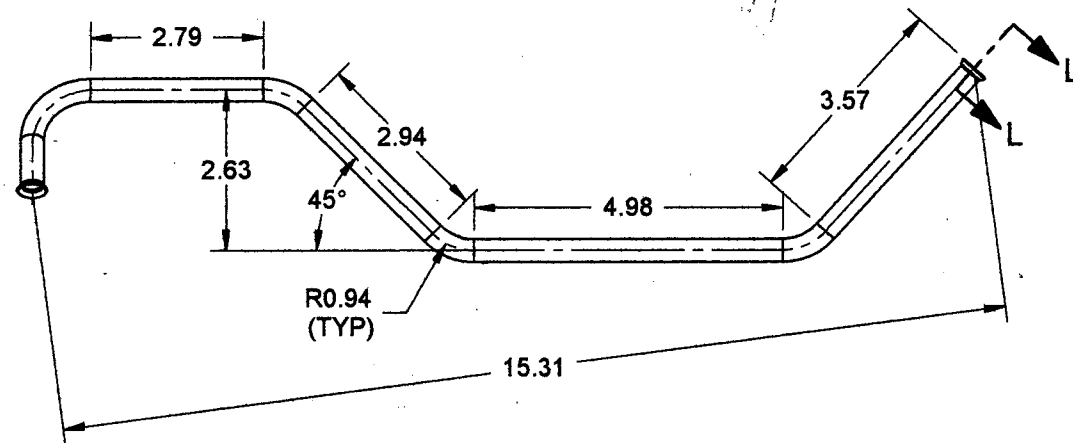
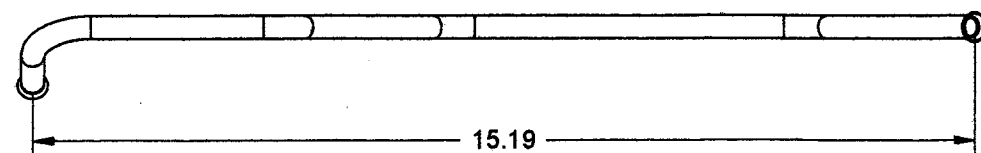
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

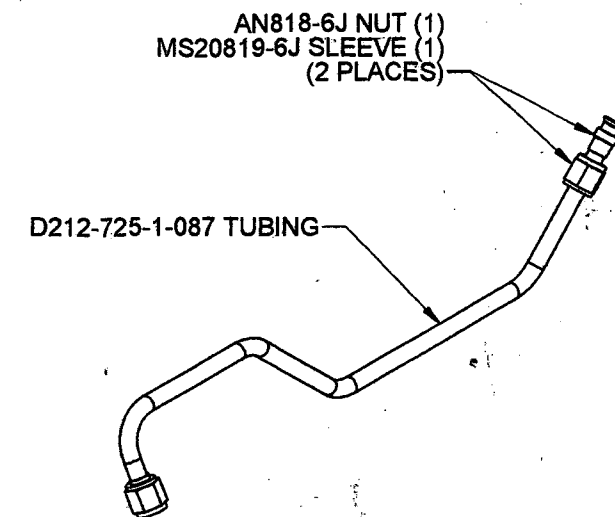
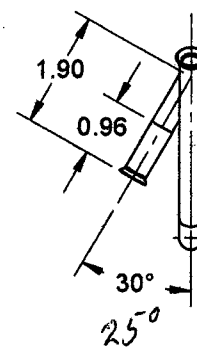
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

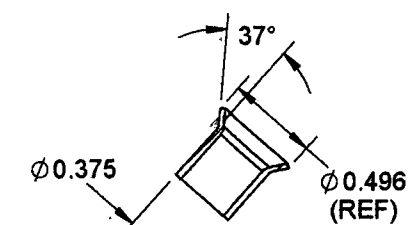
NOTE: Date & initial all entries



**D212-725-1-087 TUBING**  
MANUFACTURE PER TEMPLATE DT8910



**D212-725-1-917 TUBE ASSEMBLY**



SECTION L-L  
(FINISH FLARE ONE END  
AFTER ASSEMBLY)  
SCALE 1:1

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS  $\phi 0.375 \times 0.035$  WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D212-725-1-917 USING FINE POINT PERMANENT INK MARKER

C	07.08.23	REDRAWN
B	07.05.11	NO CHANGE
A	06.12.08	REDRAWN
DESIGN DC	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED	DRAWING NO. <b>D212-725-1</b>
DATE <b>07.08.23</b>	TITLE <b>212S DETAIL PARTS</b>	REV. C SHEET 34 OF 37 SCALE 1:3
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